

# Work Order ID 85943

**\*85943\***

Page 1

June-19-12 8:00:13 AM

Item ID: D2056

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bell Crank

Stop **\*NS2\***

Start Date: 19/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2056	Rev B2								
100		0.00							
<b>*100*</b>	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks 2.80" long								
110		0.00							
<b>*110*</b>	HAAS CNC VERTICAL-MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio D2056								
	Tumble								
	Deburr								
120		0.00							
<b>*120*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

BT 12-06-24

B.A 12/06/26

BT 12-06-25

BT 12-06-25

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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**\*20\***

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***


QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	SL 12-06-28						
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				20	20	12-6-27	
150 <b>*150*</b> Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00	8-50 3200F 9-20			20X		12/07/03	M-L

M121279

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 85943

June-19-12 8:00:13 AM

**\*85943\***

Page 3

Item ID: D2056

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bell Crank

Start Date: 19/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

20

20

20/12/07/03

170

Identify as per dwg & Stock Location: GA

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

20x

SP 12-7-3.

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/7/4

ME 12-07-03

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-19-12 8:00:18 AM

Page 1

Work Order ID: 85943

\*85943\*

Parent Item: D2056

\*D2056\*

Parent Item Name: Bell Crank

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP E02.04.04Added Rev.B2 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	12.1400	0.2375	4.6666			

\*M6061T6B1 250X01 250\*

6061-T6 Bar 1.25 x 1.25

\*\*

RT 12-06-24

Location

MAT004

119318

Loc Qty

12.14

12.14

Loc Code

4.6666

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

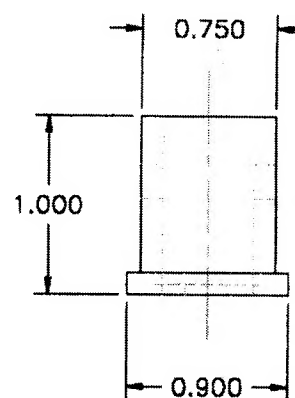
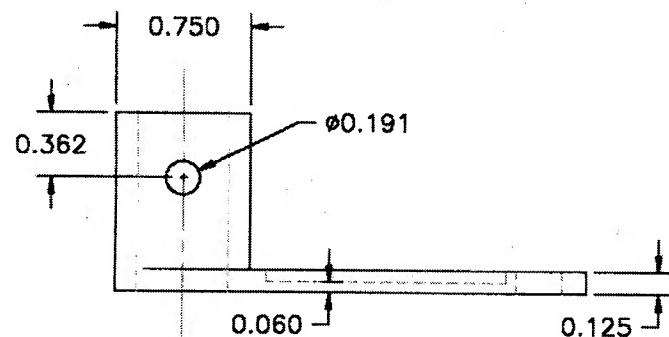
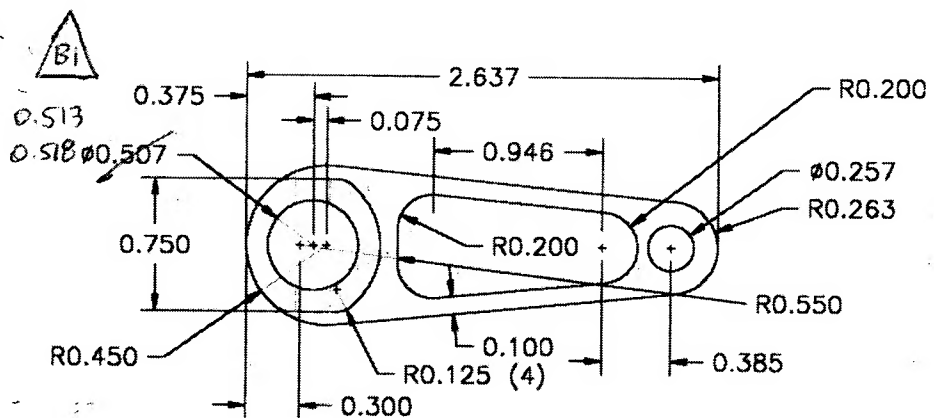


RELEASED  
99.09.29 JAE

**DART**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTIFYING  
WORK ORDER  
NO. 85943 MLJ  
12/06/19



△ B1 ACID ETCH & ALUMINE PER  
DART QSE QUS 4.1  
POWDER COAT BLACK SINTER  
(4.3.5.7) PER DART  
QSE QUS 4.3

MATERIAL: 6061-T6 (QQ-A-225/8)  
FINISH: ANODIZE (BLACK) OR  
TOLERANCES ARE PER DART QSE QUS 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. B
B WILLIAMS	K HAND	DRAWING NO.	SHEET 1 OF 1
CHECKED	APPROVED	D2056	SCALE
DATE	TITLE	BELL CRANK	1:1
92.03.13	RE-DESIGN		
B	95.11.02		
B1	01.06.04	MODIFY HOLE SIZE, ADD PIC OPTION	
B2	01.12.20	ADD NOTE ON TOLERANCES	

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	85943
<b>Description:</b> Bell Crank		<b>Part Number:</b>	D2056
<b>Inspection Dwg:</b> D2056	<b>Rev:</b> B2	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.010	.750	✓		vern	RT-4
0.900	+/-0.010	.901	✓		"	
1.000	+/-0.010	1.000	✓		"	
0.125	+/-0.010	.125	✓		"	
0.060	+/-0.010	.059	✓		mic 1"	RT-1
Ø0.191	+0.005/-0.001	.191	✓		vern	RT-4
0.362	+/-0.010	.360	✓		vern	RT-4
0.750	+/-0.010	.751	✓		"	
0.385	+/-0.010	.3885	✓		"	
Ø0.257	+0.006/-0.001	.257	✓		✓	
0.100	+/-0.010	.101	✓		"	
0.300	+/-0.010	.300	✓		"	
0.946	+/-0.010	.938	✓		"	
0.075	+/-0.010	.075	✓		"	
2.637	+/-0.010	2.638	✓		"	
0.375	+/-0.010	.375	✓		"	
Ø0.513-0.518	0.513 - 0.518	.515	✓		"	
R0.450	+/-0.010	.450	✓		"	
R0.125	+/-0.010	.125	✓		"	
R0.200	+/-0.010	.200	✓		"	
R0.550	+/-0.010	.550	✓		"	
R0.263	+/-0.010	.261	✓		"	

<b>Measured by:</b>	RT	<b>Audited by:</b>	SL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	12-06-25	<b>Date:</b>	12-06-08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.11	New Issue	KJ/DD	
B	10.02.02	Dimensions revised	KJ	

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